

Date: Tuesday, 08/04/2008 4:52:35 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET LID ASSEMBLY
Job Number :	38457B		
Estimate Number :	10207		
P.O. Number :		Part Number :	D2989043 <i>At 08.04.09</i>
This Issue :	08/04/2008	Drawing Number :	D2989 UNDER REVIEW
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11	Drawing Revision :	B
Previous Run :	38456B	Material :	
Written By :		Due Date :	30/04/2008
Checked & Approved By :	<i>50 08.4.09</i>	Qty:	1 Um: Each
Comment :	Est Rev:1 Removed D2989-041 05-11-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
2 D3182-1	Hinge	<i>B36483</i>

✓ FC 08 04 30

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number	Description	Batch
2 D3442-3	Shim	<i>B37160</i>

✓ FC 08 04 30

3.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty Part number	Description	Batch
8sf M304EX0.75-16F	Expanded Metal	<i>M10736</i>

✓ FC 08 04 30

4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SS tubing.

Batch: *107515*

✓ SAA 08/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:52:35 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 38457B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989
Note: D2989-3/-4 On -041 Bom

FL

2-Drill holes in tubing as D2989-043 per Dwg D2989

FL

3-Deburr and remove all markings on material

pad 08/04/27

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

FL/PD 0805-01

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

FL 08 04 30

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/05/01

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/05/01

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

11107550

#4
1338457D
D2989043
01/05/2008
S.176 15.49
#1 403.9
#2 30
#3 m-fus
#4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

M. H.

08/05/01

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/02

Job Completion



MF 08-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19 *[Signature]*

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

UNDER REVIEW
08.07.05 *[Signature]*

TUBING TO BE
CHANGED TO 0.065"
WALL
[Signature]
03.04.09

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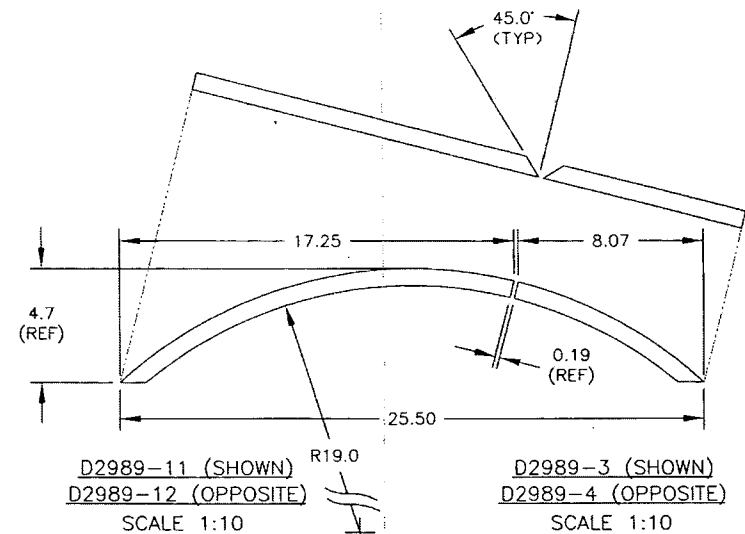
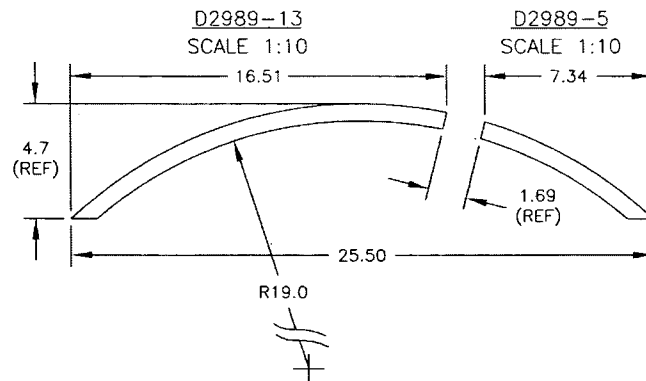
WORK ORDER
NO. **B38457B**

NOTES:

- 0.065" *[Signature]* 01.04.09
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x ~~0.060~~ WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
 - 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
 - 3) WELD PER DART QSI 004
 - 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

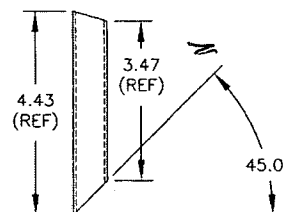
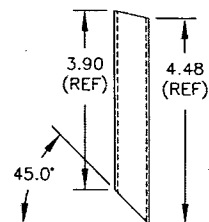
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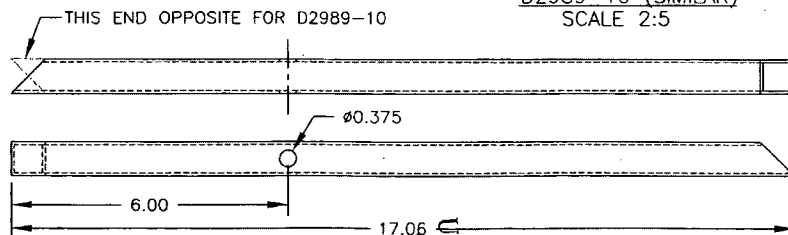


D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

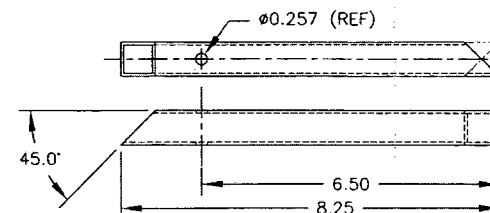
D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



D2989-1 (SHOWN)
D2989-2 (OPPOSITE)
SCALE 2:5



UNDER REVIEW
05.06.07
TUBING TO BE
LIFTED TO CLOS
WALL
05.04.09

RELEASED
05.08.19

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DATE 05.06.07		TITLE BASKET LID ASSEMBLY		SCALE 1:10	

WORK ORDER
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